

Date: Monday, 4/23/2007 1:52:49 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET		
Job Number	: 31997					
Estimate Number	: 12713					
P.O. Number	: N/A		Part Number	: D353641		
This Issue	: 4/23/2007	S.O. No. : N/A	Drawing Number	: D3536 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: N/A		Material	: N/A		
Written By			Due Date	: 4/30/2007 Qty: 20 Um: Each		
Checked & Approved By						
Comment	: Est Rev:A New Issue 07-02-14 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	MNEO60S063	NEOPRENE SHEET 0.063			
	Comment: Qty.: 0.7144 sf(s)/Unit Total : 14.2884 sf(s) NEOPRENE SHEET 0.063 Batch: M103104		SAD	07/05/03	20
2.0	WATER JET	FLOW WATER JET			
	Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A		SAD	07/05/03	20
	2-Deburr if necessary				
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		SAD	07/05/03	20
4.0	QC8	SECOND CHECK			
	Comment: SECOND CHECK		B6	07-05-04	20
5.0	PACKAGING 1	PACKAGING RESOURCE #1			
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Rm 544c		C15-py	(20)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3536-841 PAR #: \_\_\_\_\_ Fault Category: Prod/Engines <sup>Cardinal</sup> NCR: Yes No DQA: D Date: 06/07  
 QA: N/C Closed: Q Date: 01/08

NCR: <u>31997</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/05/04</u>	<u>2.0</u>	<u>Welding dim.</u>						
<u>07/05/04</u>	<u>2.0</u>	Dimensions were not correct Dxf width error. It had the remainder of the material for the wearplate	<u>QS1042</u>	Scrap - destroy - replace Dxf corrected.	<u>SAD</u> <u>07/05/04</u>	<u>07/05/04</u>	<u>QS1042</u>	<u>07/05/04</u>
		Joggle.						

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31997

Part Number: D353641

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(2d)

Comment: FINAL INSPECTION/W/O RELEASE

15.05.09

Job Completion



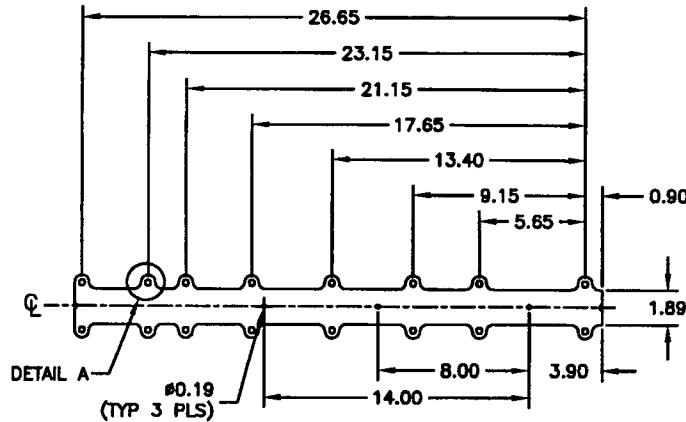
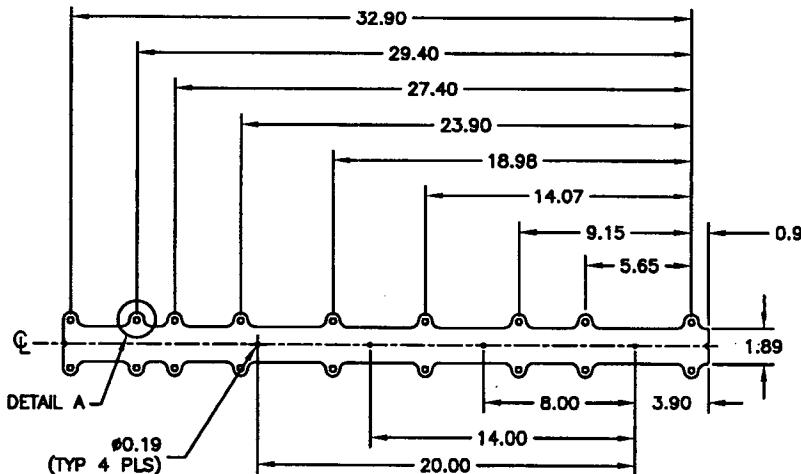
il 07.05.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**DRAFTING  
BY  
JAS**D3536-11 GASKET****D3536-13 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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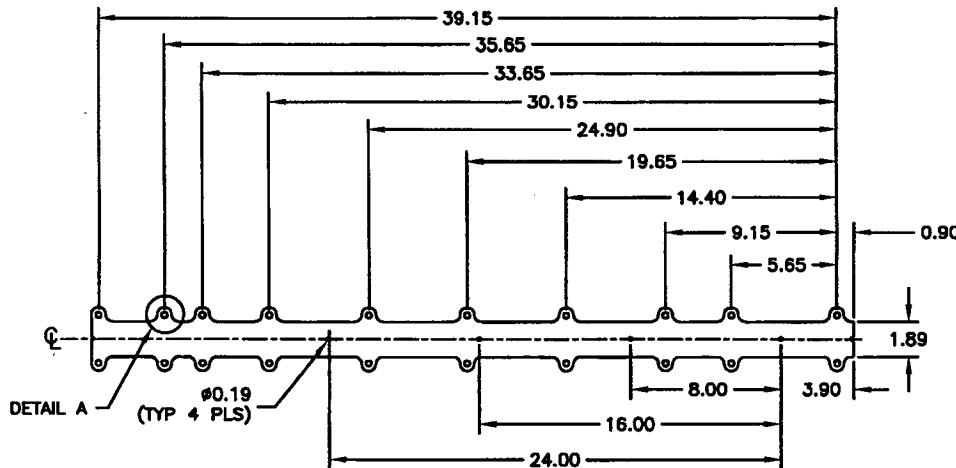
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WITHOUT NOTICE  
WORK ORDER  
NO. 31897

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CHECKED <b>PH</b>	APPROVED <b>SH</b>	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
A	06.10.25	NEW ISSUE

REV. A  
SHEET 1 OF 6  
SCALE  
1:10

**DART**

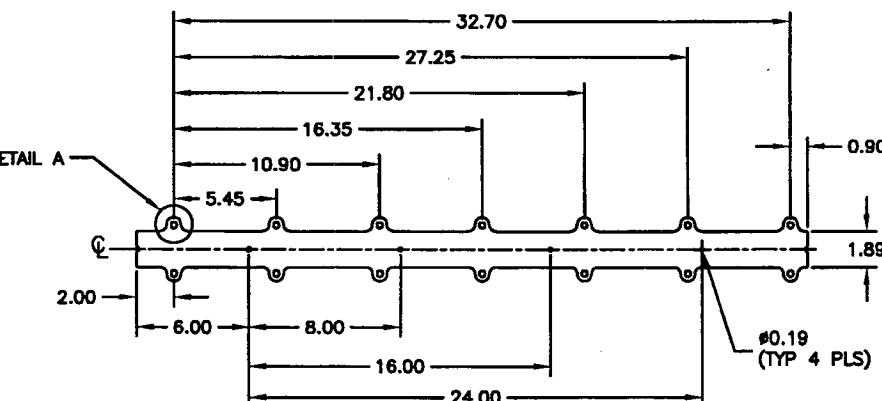
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CHECKED <b>PW</b>	APPROVED <b>TH</b>	DRAWING NO. <b>D.3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 2 OF 6 SCALE <b>1:10</b>

P/N D3536-15 GASKET  
07.02.12**D3536-15 GASKET**

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NO. 3195

**NOTES**

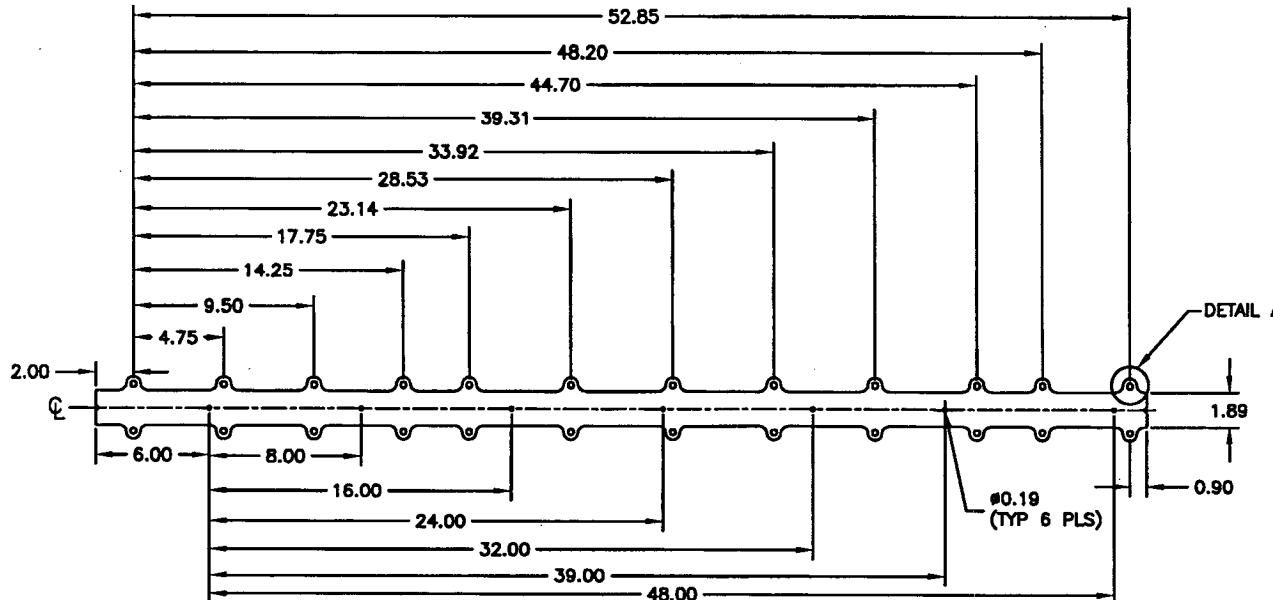
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-21 GASKET**

**DART**

07-02-12  
PULL REQUESTED

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C.B	C.B	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
P.H.	JH	D3536
DATE	TITLE	SHEET 3 OF 6
06.10.25	GASKET	SCALE

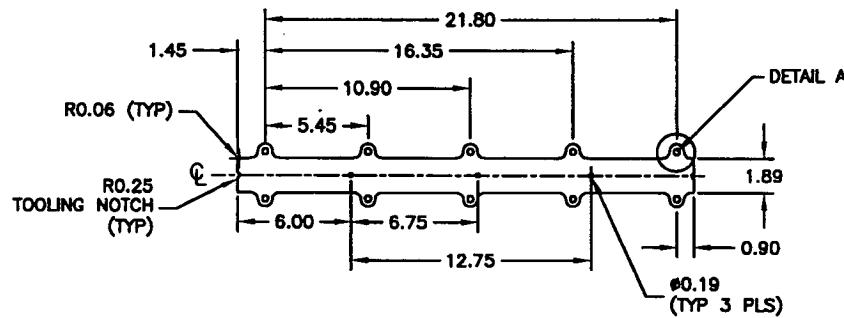


**D3536-23 GASKET**

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WORK ORDER NO. 31987

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



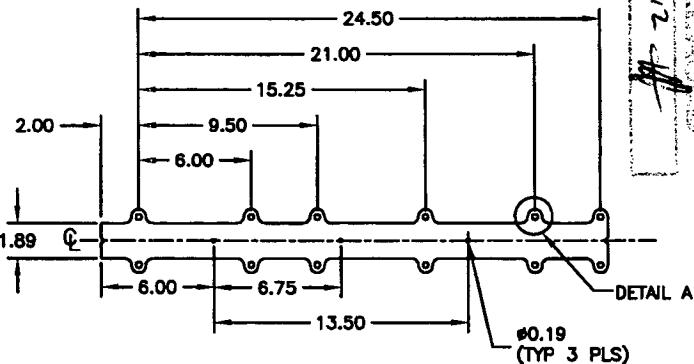
**D3536-25 GASKET**

**DART**

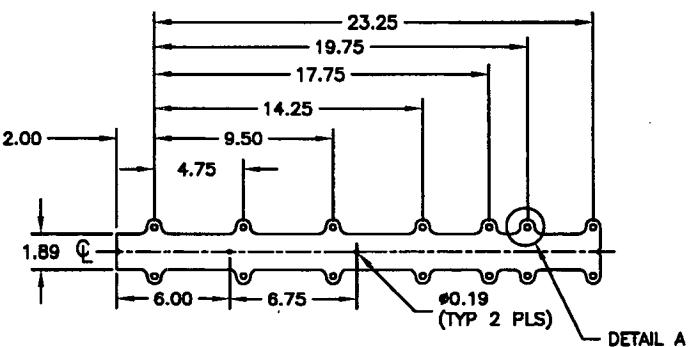
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C.B	C.B	PORT HADLOCK, WA
MM	MM	REV. A
06.10.25		SHEET 4 OF 6
		SCALE

DRAWING NO. D3536  
TITLE GASKET

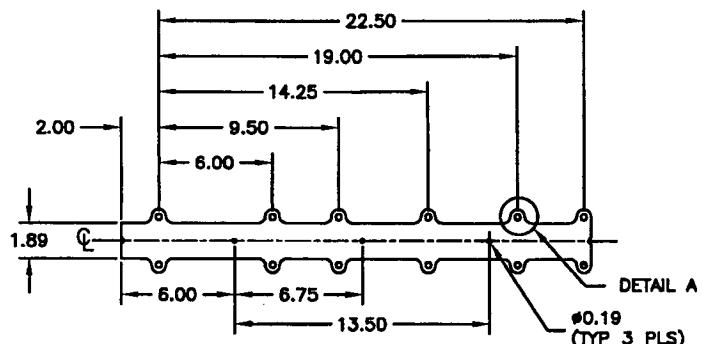
RELEASED 07.02.12



**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

**NOTES**

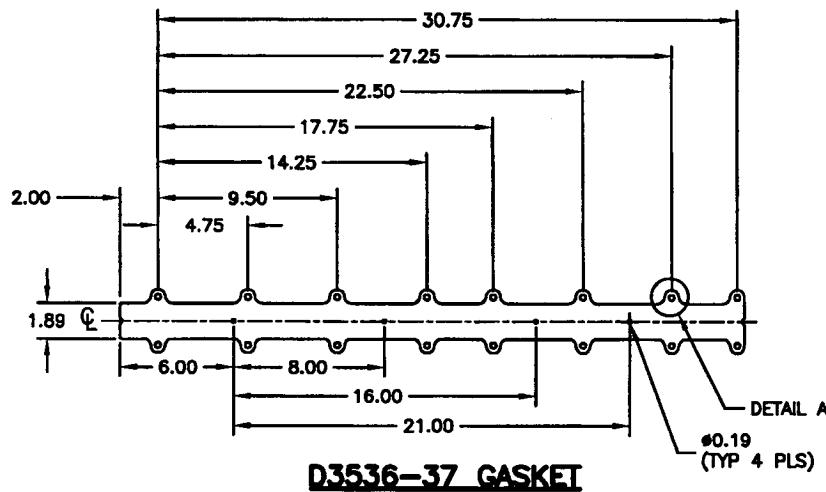
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WORK ORDER  
NO. 31997

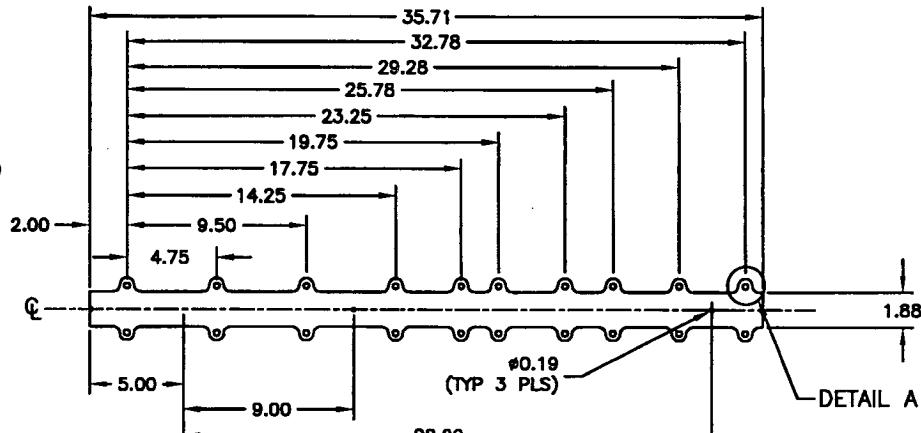
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DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 5 OF 6 SCALE <b>1:10</b>

07.02.02  
H

**D3536-37 GASKET****NOTES**

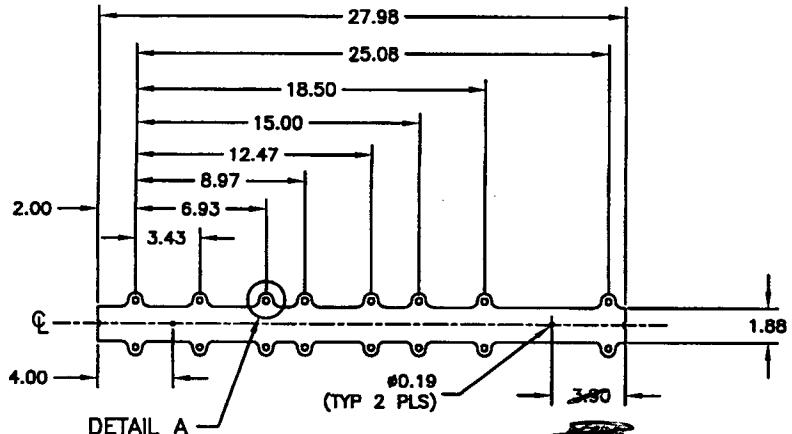
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-39 GASKET**

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NO. **319817**

**DART**

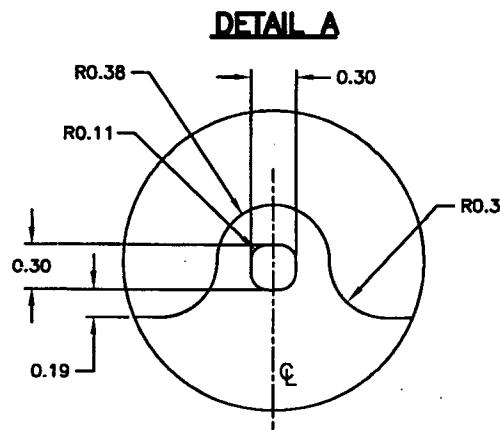
07.02.12



**D3536-41 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



DESIGN <b>C.B</b>	DRAWN BY <b>C.B</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <b>M</b>	APPROVED <b>M</b>	DRAWING NO. <b>D3536</b>	REV. A	SHEET 6 OF 6
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SCALE <b>1:10</b>		

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WORK ORDER  
NO. 31997

DART AEROSPACE LTD

Work Order: 31997

Description: GASKET

Part Number: D3536 - 41

Inspection Dwg: D3536 Rev: A

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article     Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 27.98	+/- 0.030	28.00	✓		Vern/HMT	
B 25.08	+/- 0.030	25.08	✓		H-T/Vern	
C 18.50	+/- 0.030	18.50	✓		H-T	
D 15.00	+/- 0.030	15.00	✓		H-T	
E 12.47	+/- 0.030	12.480	✓		H-T Vern	
F 8.97	+/- 0.030	8.98	✓		H-T/Vern	
G 6.93	+/- 0.030	6.93	✓		Vern	
H 3.43	+/- 0.030	3.43	✓		Vern	
I 2.00	+/- 0.030	2.00	✓		Vern	
J 4.00	+/- 0.030	4.01	✓		Vern	
K Ø 0.19	+/- 0.030	Ø 0.19	✓		Vern	
L 1.88	+/- 0.030	1.90	✓		Vern	
M 0.30	+/- 0.030	0.30	✓		Vern	
N 0.30	+/- 0.030	0.30	✓		Vern	
O 0.063	+/- 0.010	0.060	✓		Vern	
P 5.00	+/- 0.030		AAJ		Vern	
Q 3.90	+/- 0.030	3.890	✓		Vern	
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAY
Date:	07/05/04

Audited by:	JK
Date:	67.05.04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

